

Work Order ID 85970 - 2

June-19-12 11:58:34 AM

85970

Page 1

Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Litter Tie Down Assembly

Stop

NS2

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2341

Rev F

D2360

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.65" Long

PO/12/07/20

8

0

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2341 and Dwg D2341
2-Deburr


PO/12/07/25

12/07/25

PTO

W/O: 8970		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2360 PAR #: Fault Category: machining NCR: Yes No DQA Date: 12/08/02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/8/2

NCR: 121650		WORK ORDER NON-CONFORMANCE (NCR) # 260.99						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/27	110	QTY(2) HAVE MOST DIMS IN "Y" UNDER TOLERANCE. QTY(1): 0.010" TO 0.015" UNDER IN "Y". QTY(1): 0.030" TO 0.035" UNDER IN "Y".	DAS 22 12/07/27	PART W/0.010" TO 0.015" UNDER TOL IN "Y" IS ACCEPTABLE AS IS. PART W/0.030" TO 0.035" UNDER TOL IN "Y" IS SCRAPPED.	12-07-27	DAS 14 12/07/27	DAS 22 12/07/27	DAS 16 12/07/27
				No Replace				
		R-L Parts move / offset off.						

NOTE: Date & initial all entries

Work Order ID 85970***85970***

Page 2

June-19-12 11:58:34 AM

Item ID: D2360

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

PO

12/07/25

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

DAS
14
2-89

12/07/27

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

7

7/6 12-7-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 85970

June-19-12 11:58:34 AM

85970

Page 3

Item ID: D2360

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Litter Tie Down Assembly

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
3200 F
12:15

0.00

7X

MZ
12/07/30

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

7X

12/07/30

170

Small Fab

0.00

170

Small Fab

Small Fab

Memo

Assemble as per dwg D2360

0.00

6X

12/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D2360

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

SMB
12-8-01

DAS
16
2-83 17/08/01

6

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location 321

0.00

190

Packaging

Memo

0.00

Packaging

12/8/01

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/08/01

12/08/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:58:38 AM

Page 1

Work Order ID: 85970

85970

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201		Manufactured	No			100	f	77.3800	1.054	4.437895			

D6201

"T" Extrusion

**

PO 12/07/20

M121643

Location

Loc Qty

Loc Code

8.876

MAT004

2.04

57767

1.34

71208

0.7

MAT028

69

81421

49

83987

20

MAT28

6.34

77491

5.34

81421

1

~~8.876~~

AN526C1032R18

Purchased

No

170

Each

648.0000

1

4

AN526C1032R18

Screw

**

EP 12/07/31

Location

Loc Qty

Loc Code

FP002

93

4523

93

ST348

555

101458

36

108079

419

110099

100

~~7.7~~

AN960JD10

NAS1149D0363J Purchased

No

170

Each

0.0000

2

8

AN960JD10

Washer

**

EP 12/07/31

4 M12 1524
140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:58:38 AM

Page 2

Work Order ID: 85970

85970

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD10L

NAS1149D0332J Purchased

No

*AN960.ID10I *

Washer

D2002-015

Manufactured

No

D2002-015

Knob

170 Each 0.0000

8

32

**

170 Each 25.0000

2

8

**

Location

Loc Qty

Loc Code

Mezz

23

16177

23

ST002

2

83480

2

D2345

Manufactured

No

170 Each

12.0000

1

**

D2345

Lock Channel

Location

Loc Qty

Loc Code

ST011

12

70800

12

D2366

Manufactured

No

170 Each

13.0000

2

**

D2366

Lock Handle

Location

Loc Qty

Loc Code

ST008

13

73333

13

D2367

Manufactured

No

170 Each

16.0000

1

**

D2367

Handle Knob

Location

Loc Qty

Loc Code

ST008

16

68883

4

83541

12

June-19-12 11:58:38 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:58:38 AM

Page 3

Work Order ID: 85970

85970

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2372 Manufactured No

170 Each 18.0000 2 8

D2372

Quick Release

**

Location

Loc Qty

Loc Code

ST

18

80274

2

80510

16

D2373 Manufactured No

170 Each 14.0000 1 4

D2373

Spring

**

Location

Loc Qty

Loc Code

ST008

14

66118

4

81892

10

D2444 Manufactured No

170 Each 13.0000 1 4

D2444

Pip Pin Assembly

**

Location

Loc Qty

Loc Code

ST019

13

79477

13

MS20470AD3-4 Purchased No

170 Each 8,447.000 1 4

MS20470AD3-4

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

8447

111477

8332

15541

115

EP 12/07/31
B86928 (13)

B86001 (10)
EP 12/07/31

43
EP 12/07/31
386002 (7x)

EP 12/07/31
77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

June-19-12 11:58:38 AM

Page 4

Work Order ID: 85970

85970

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

170

Each

1.693.000

3

12

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

1693

117885

32

119017

816

119075

138

121444

707

MS27039-1-13

Purchased

No

170

Each

109.0000

1

4

MS27039-1-13

Screw

**

Location

Loc Qty

Loc Code

ST291

109

110844

9

119736

100

MS27039-1-15

Purchased

No

170

Each

31.0000

2

8

MS27039-1-15

Screw

**

Location

Loc Qty

Loc Code

ST291

31

118574

2

119736

1

121243

28

NAS679A3W

Purchased

No

170

Each

202.0000

1

4

NAS679A3W

Nut

**

Location

Loc Qty

Loc Code

GA

15

1463

15

2409

187

June-19-12 11:58:38 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25970
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	✓		VERN	PHD-01
2.75	+/-0.030	2.760	✓		"	"
Ø0.242	+0.005/-0.001	0.242	✓		"	"
Ø0.191	+0.005/-0.001	0.191	✓		"	"
R0.25	+/-0.030	0.250	✓		R.G.	
R0.40	+/-0.030	0.400	✓		R.G.	
12.50	+/-0.030	12.500	✓		M TAPE	PHD-11
11.750	+/-0.010	11.750	✓		VERN	CNC-02
11.00	+/-0.030	11.000	✓		"	PHD-01
7.00	+/-0.030	7.002	✓		"	CNC-02
6.250	+/-0.010	6.251	✓		"	"
5.50	+/-0.030	5.499	✓		"	PHD-01
1.50	+/-0.030	1.504	✓		"	"
0.750	+/-0.010	0.755	✓		"	"
0.400	+/-0.010	0.399	✓		"	"
1.584	+/-0.010	1.590	✓		"	"
2.610	+/-0.010	2.611	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.844	+/-0.010	0.842	✓		"	"
Ø0.250	+/-0.010	0.250	✓		"	"
0.750	+/-0.010	0.751	✓		"	"
3.313	+/-0.010	3.312	✓		"	"
4.250	+/-0.010	4.249	✓		"	"
1.250	+/-0.010	1.249	✓		"	"

Measured by: 80	Audited by: DAS 14	Prototype Approval:	N/A
Date: 12/07/25	Date: 12/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED HA	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07.06.07

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 05970 MCT
12/06/19

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

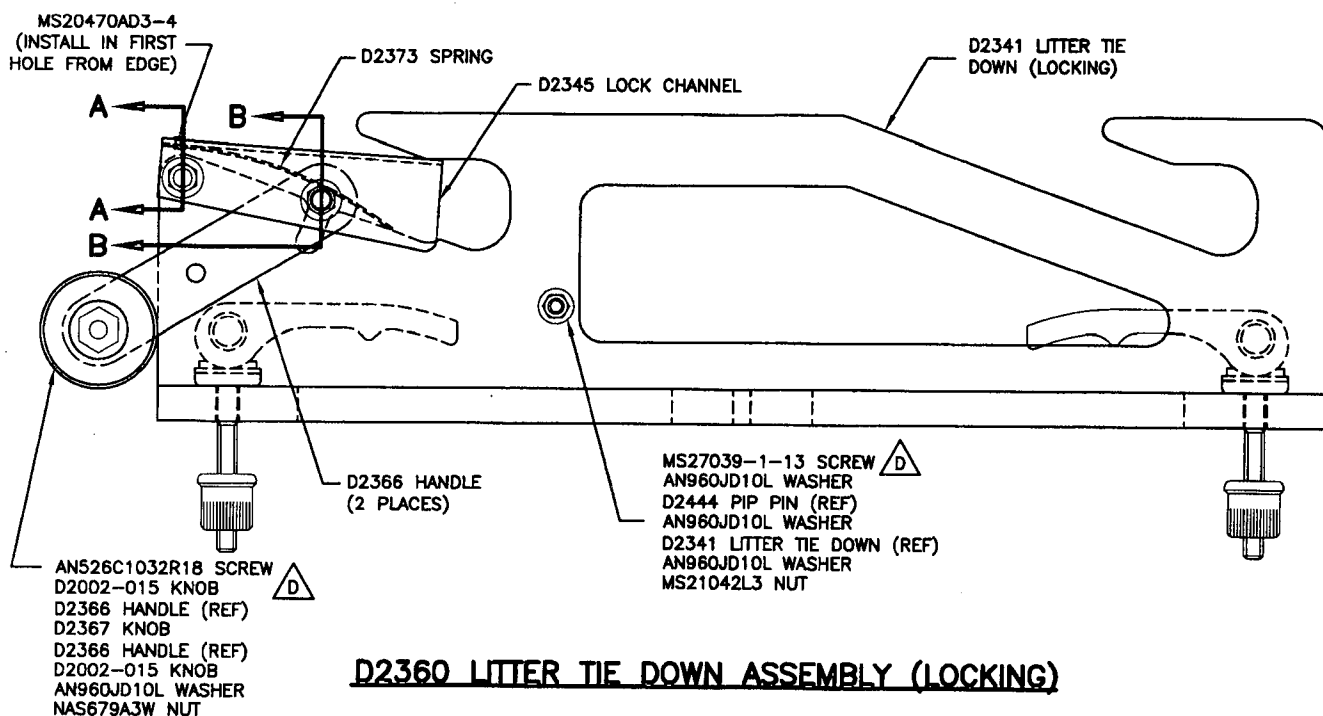
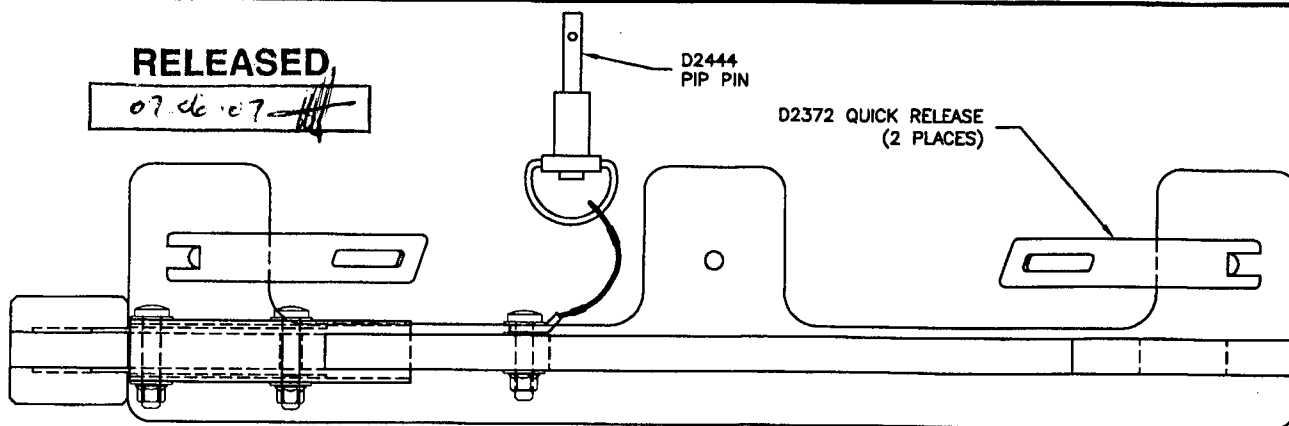
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

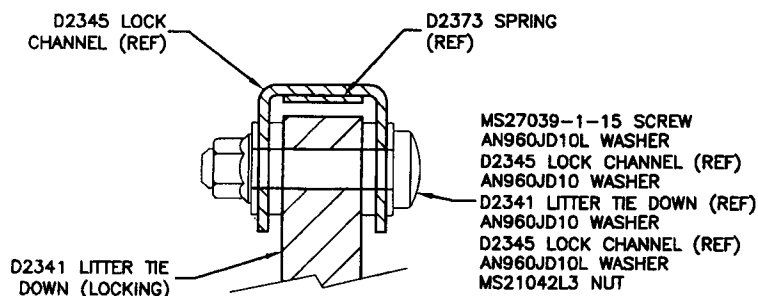
NOTE: Date & initial all entries



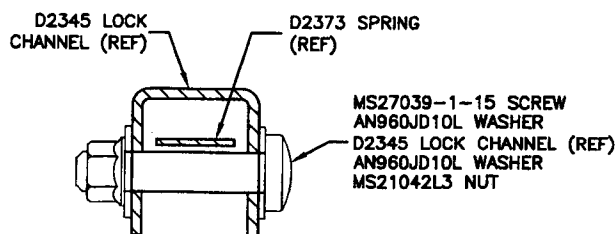
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) MTS		



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

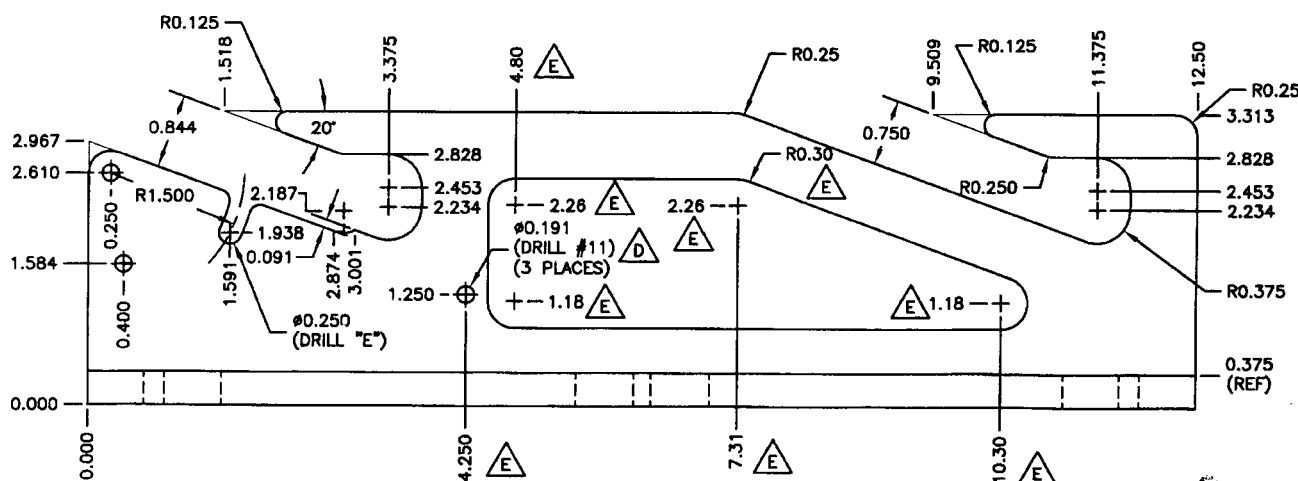
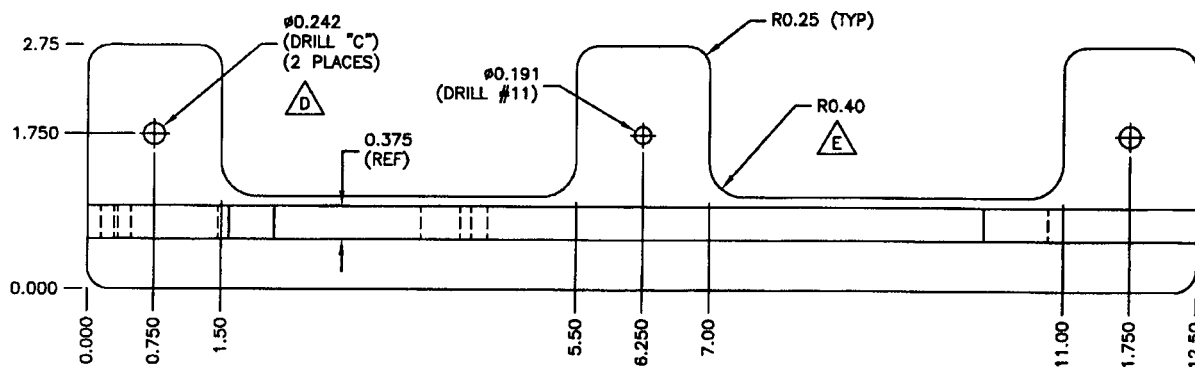
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER TIE DOWN BRACKET (LOCKING) SCALE 1:2		
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	



D2341 LITTER TIE DOWN BRACKET (LOCKING)

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

RELEASED

07-6-22

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WORK ORDER
NO. 85770 MCB

12/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries